

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
690 Walnut Ave.St. 150  
Vallejo, CA 94592-1133  
(707) 649-5453  
(707) 649-5493

Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 1.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-012992**Date Inspected:** 09-Apr-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 630**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1500**Contractor:** American Bridge/Fluor Enterprises, a JV**Location:** Job Site**CWI Name:** Listed below.**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Orthotropic Box Girders (OBG)**Summary of Items Observed:**

The Quality Assurance Inspector (QAI), Scott Croff, was present at the Self Anchored Span (SAS) job site to observe the scheduled fabrication and welding of components for the SFOBB project. The following observations were made:

- 1) OBG Lifts 1W/2W - plate E field splice welding
- 2) OBG Lifts 1E/2E - plate E field splice weld repairs

1) The QAI observed ABF personnel welding plate D at OBG Lifts 1W/2W field splice. The QAI noted that this flat position (2G) complete joint penetration (CJP) weld is being made in segments D1 through D19. The QAI noted that the Quality Control (QC) Inspector Bernie Docena is monitoring this welding. The QAI observed ABF workers Jordan Hazelaar, ID 2135, Kenneth Chappell, ID 3833, Chun Fai Tsui, ID 3426, and James Zhen, ID 6001, making the welds with shielded metal arc welding (SMAW) with 1/8" diameter E7018-H4R electrode. The QAI was also informed that the weld segments where the stiffener plates intersect are being completely welded using welding procedure specification (WPS) ABF-WPS-D15-1040C. During the shift, the QAI randomly measured the preheat, interpass temperature and welding parameters and noted that they appeared to be conforming to the WPS requirements. This work was in progress at the end of the QAI's shift.

2) The QAI observed ABF personnel back welding plate C at OBG Lifts 1E/2E field splice. The QAI noted that the overhead position (4G) complete joint penetration (CJP) weld segments C1 and C2 are being completed after the backing bar has been removed. The QAI noted that the Quality Control (QC) Inspector Jim Cunningham is monitoring this welding. The QAI observed ABF personnel Jeremy Dolman, ID 5042 and Rory Hogan, ID 3186,

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making the welds with gas shielded flux cored arc welding (FCAW-G). At the start of the shift, the QAI made general observations of the back gouged groove and noted that it was ground to bright clean metal. See the attached photo. The QAI was informed that ABF-WPS-D15-3040A-1 is being used for this welding. As the welding commenced, the QAI randomly measured the preheat, interpass temperature and welding parameters and noted that they appeared to be conforming to the WPS requirements. This welding was in progress at the end of the QAI's shift. See the attached photo.



### Summary of Conversations:

The QAI relayed the observations of welding to the QAI Danny Reyes and the QAI Lead Bill Levell. The QAI also generated a shift turn-over report with this information. There were no other notable observations or conversations during this shift.

### Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Mohammad Fatemi, (916)813-3677, who represents the Office of Structural Materials for your project.

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<b>Inspected By:</b>	Croff, Scott	Quality Assurance Inspector
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<b>Reviewed By:</b>	Levell, Bill	QA Reviewer
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